



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3155-042
Job Sheet 198440



Part No: D3155-042

Job Qty: 2 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/29/19

Job Tracking No:

Due Date: 9/3/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 13294

Note: DWG D3155 REV D IPP B 03.02.03 Reformat KJ/RF IPP Rev:C As per Rev D 07-06-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	2 pcs		9/3/19	0.00	0.10	Bandsaw - 1		DAS 52 9-89 19/07/19
110	HAAS 4 Axis - B4B	2 pcs		9/3/19	1.00	2.00	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		DAS 52 9-89 19/07/19
120	QC 2	2 pcs		9/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		DAS 52 9-89 19/07/19



Dart Aerospace Ltd.
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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S213750



Part: D3155-042

Job No: 198440

Serial No/Batch: S213750

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/14/19

Plex 7/29/19 1:16 PM Dart.Renwick.Jennifer

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	2 pcs	9/3/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Handfinish - 1-1 Chemical- B4B	2 pcs	9/3/19	0.00 0.20	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 3	2 pcs	9/3/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	

19/9/21

SEP 23 2019

https://www.plexonline.com/2870f91a-9780-40d6-8c3f-ef5a1e444ebb/Plexus_Control/Report_Viewer_2.asp?URL=https://www.plexonline.com/2870f91... 3/4

SFC 19

GA+TRD DAS
SEP 25 2019 70
9-89

SFC 19

Container
3110498
FSL286

SFC 19

SFC 19

SFC 19

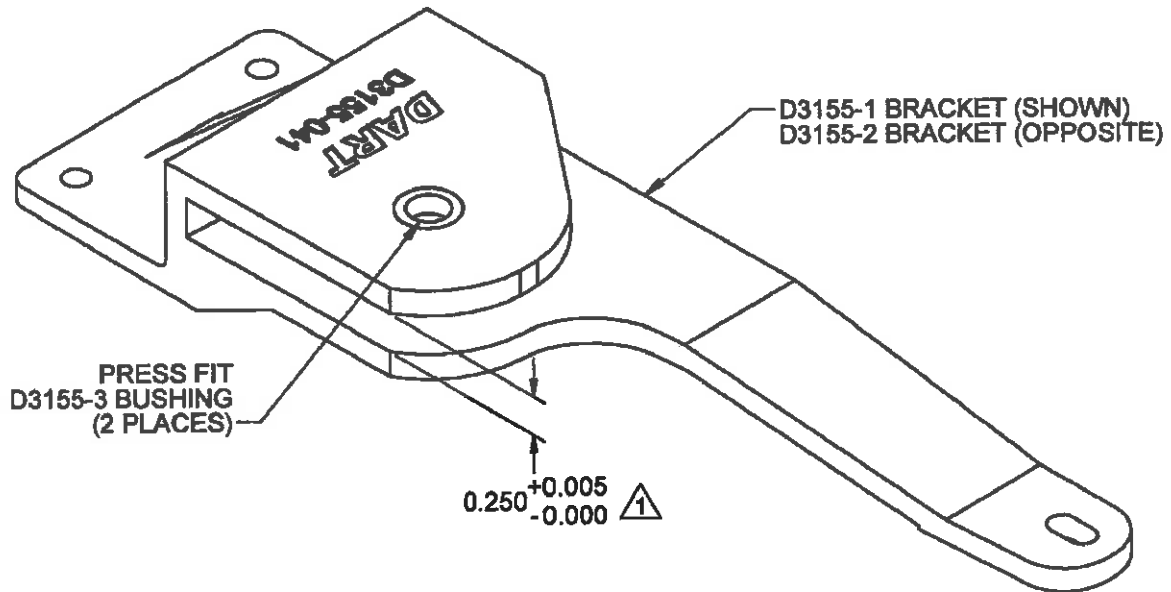
SFC 19

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3155	REV. D SHEET 1 OF 3
DATE 07.01.18	TITLE BRACKET ASSEMBLY		SCALE 1:1
REV	DATE	DESCRIPTION	
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	
D	07.01.18	ON D3155-1/-2, 0.699 DIM WAS REMOVED; 0.887 WAS 0.882; 3.150 WAS 3.148; ADD 0.250 DIM +0.005/-0.000	

RELEASED

07.06.04 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198440

D3155-041 BRACKET ASSEMBLY
(SHOWN, REPLACE PREMIER P/N B30-23000-11)
D3155-042 BRACKET ASSEMBLY
(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3155-041	BRACKET ASSEMBLY
	X	D3155-042	BRACKET ASSEMBLY
1		D3155-1	BRACKET
	1	D3155-2	BRACKET
2	2	D3155-3	BUSHING

NOTE:

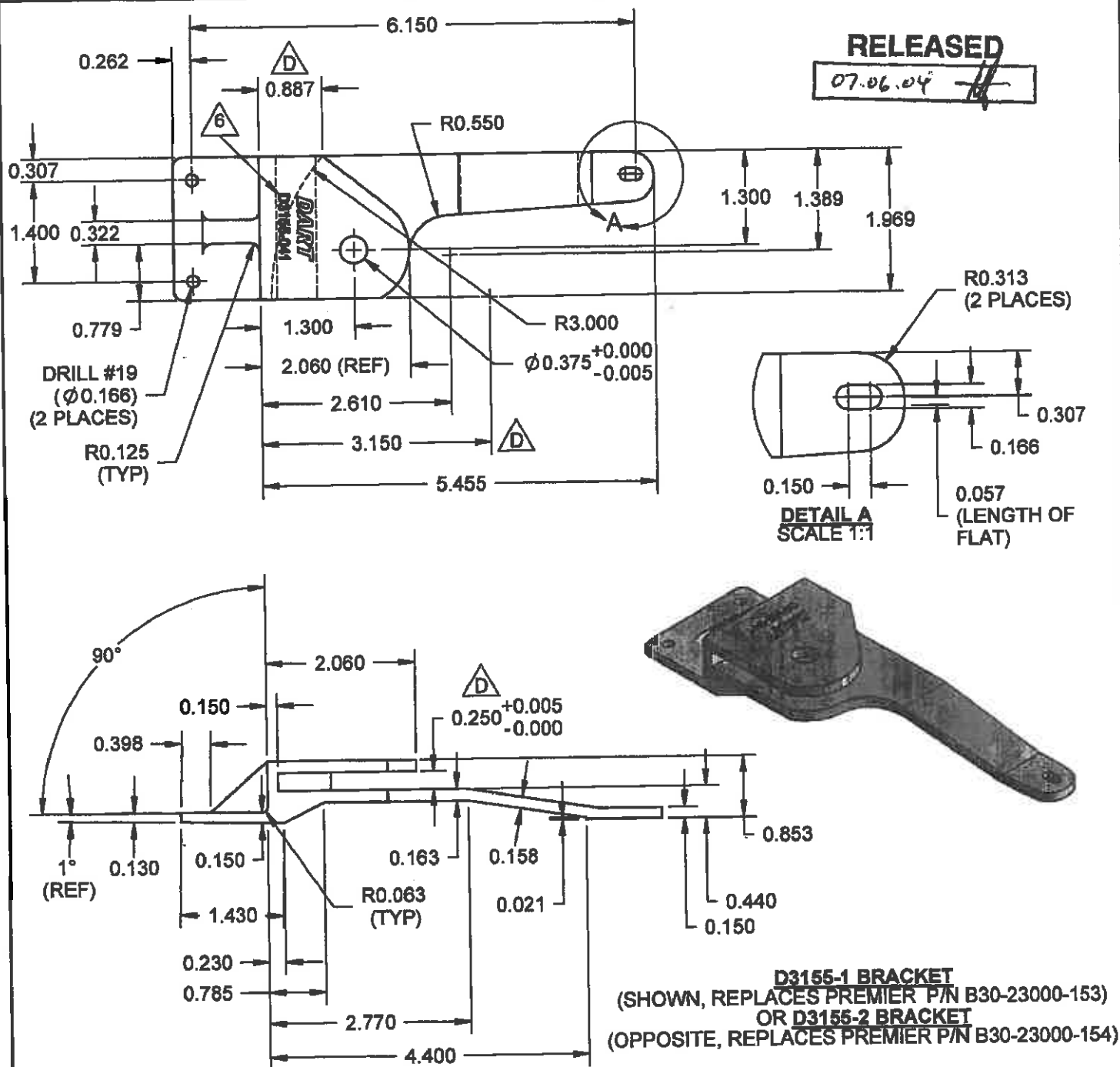
1 MAINTAIN THE $0.250^{+0.005}_{-0.000}$ DIMENSION AFTER PRESS FITTING THE BUSHING.

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3155	REV. D SHEET 2 OF 3
DATE 07.01.18	TITLE BRACKET ASSEMBLY		SCALE 1:2



NOTES:

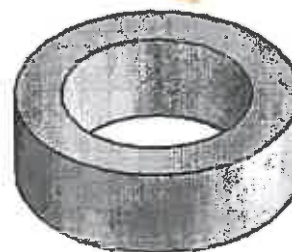
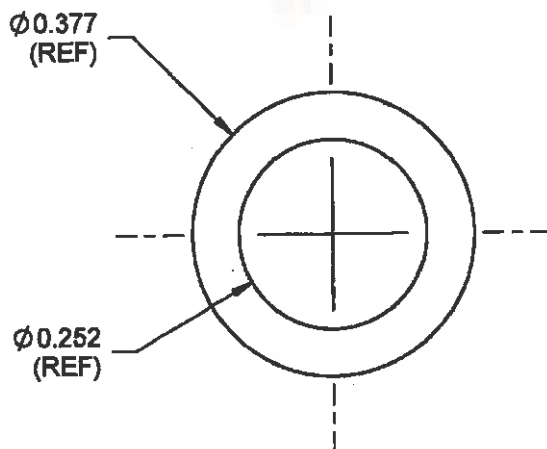
- 1) MATERIAL: ALUMINUM BAR 6061-T6/-T651 PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117 OR AMS 4128 OR AMS 4115 OR AMS 4116 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN TO MAX DEPTH OF 0.010 WITH A MIN RAD OF 0.010

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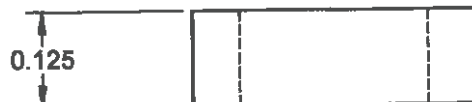


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3155	REV. D SHEET 3 OF 3
DATE 07.01.18		TITLE BRACKET ASSEMBLY	SCALE 4:1



RELEASED

07.06.04 -#



D3155-3 BUSHING

NOTES:

- 1) MATERIAL: MAKE FROM SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3065-5DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number: D3155-2	
Inspection Dwg: D3155 Rev: <i>CD</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.166	+0.005/-0.001	<i>Ø0.166</i>	<i>✓</i>		<i>G.P.</i>	
Ø0.375	+0.000/-0.005	<i>Ø0.374</i>	<i>✓</i>		<i>G.P.</i>	
6.150	+/-0.010	<i>6.149</i>	<i>✓</i>		<i>H.G.</i>	
0.262	+/-0.010	<i>0.262</i>	<i>✓</i>		<i>Ver.</i>	
1.400	+/-0.010	<i>1.400</i>	<i>✓</i>		<i>Ver.</i>	
0.307	+/-0.010	<i>0.307</i>	<i>✓</i>		<i>Ver.</i>	
1.969	+/-0.010	<i>1.969</i>	<i>✓</i>		<i>Ver.</i>	
0.322	+/-0.010	<i>0.322</i>	<i>✓</i>		<i>Ver.</i>	
0.779	+/-0.010	<i>0.776</i>	<i>✓</i>		<i>H.G.</i>	
0.166	+/-0.010	<i>0.166</i>	<i>✓</i>		<i>Ver.</i>	
0.307	+/-0.010	<i>0.307</i>	<i>✓</i>		<i>Ver.</i>	
1.300	+/-0.010	<i>1.300</i>	<i>✓</i>		<i>Ver.</i>	
0.130	+/-0.010	<i>0.135</i>	<i>✓</i>		<i>Ver.</i>	
0.150	+/-0.010	<i>0.157</i>	<i>✓</i>		<i>Ver.</i>	
0.150	+/-0.010	<i>0.150</i>	<i>✓</i>		<i>Ver.</i>	
0.853	+/-0.010	<i>0.853</i>	<i>✓</i>		<i>H.G.</i>	
0.163	+/-0.010	<i>0.163</i>	<i>✓</i>		<i>Ver.</i>	
R0.063	+/-0.010	<i>R0.063</i>	<i>✓</i>		<i>R.G.</i>	
5.455	+/-0.010	<i>5.455</i>	<i>✓</i>		<i>Ver.</i>	
4.600	+/-0.010					
2.060	+/-0.010	<i>2.060</i>	<i>✓</i>		<i>Ver.</i>	
0.021	+/-0.010	<i>0.023</i>	<i>✓</i>		<i>Ver.</i>	
<i>0.250</i>	<i>+0.005 - 0.00</i>	<i>0.250</i>	<i>✓</i>		<i>G.P.</i>	

Measured by: <i>52</i>	Audited by: <i>HJ</i>	Prototype Approval:	N/A
Date: <i>19/09/14</i>	Date: <i>19/9/14</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue P/O D3155-042	KJ/JLM	<i>[Signature]</i>